Date: Tuesday, 02/06/2009 3:55:33 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: RIB
Job Number	: 48330		
Estimate Number	: 13671		
P.O. Number	:	**Part Number**	: D29895
This Issue	: 02/06/2009 **S.O. No.** :	**Drawing Number**	: D2989 REV D (PG.5)
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LARGE FAB ASSY	**Drawing Revision**	: D
Previous Run	: 46304	**Material**	:

Written By	:	**Due Date**	: 09/06/2009	**Qty:**	4 **Um:**	Each

Checked & Approved By : _JW 09.06.02_

Comment : Est Rev:A 08-12-02 new issue DD verified by:EC

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
✓ 1.0	D31663	Basket Hoop

Comment: Qty.:   0.0840 Each(s)/Unit   Total :   0.3360 Each(s)
Basket Hoop _46629_ = _0.0840_
batch: _47073_ = _0.2520_   _SAD   09-06-08_

Seq. #:	Machine Or Operation:	Description :
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1- pick D3166-3 to cut D2989-5 rib as per dwg D2989 using DT9442 jig
2- remove identification markings
3- deburr
SAD   09-06-08

Seq. #:	Machine Or Operation:	Description :
3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
_J 09/06/08_

Seq. #:	Machine Or Operation:	Description :
4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _Basket_   _PD 09-06-08_

Seq. #:	Machine Or Operation:	Description :
5.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE
_09/06/09_

Job Completion   _MF 09-06-08_

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

16.51

7.34

4.67

1.70
REF

3.91

R19.00

D2989-13 RIB

D2989-5 RIB

R19.00

25.50

0.75 X 45°
CHAMFER
2 PL

96.00

D2989-17 RIB

0.75
REF

0.065
REF

0.75
REF

31.19

D2989-19 RIB
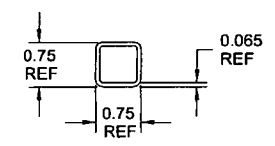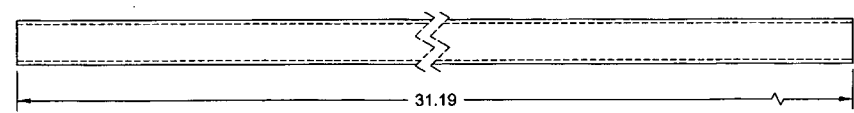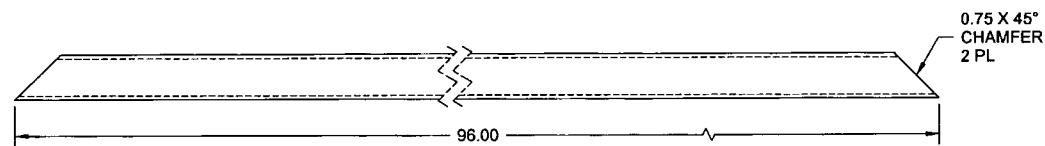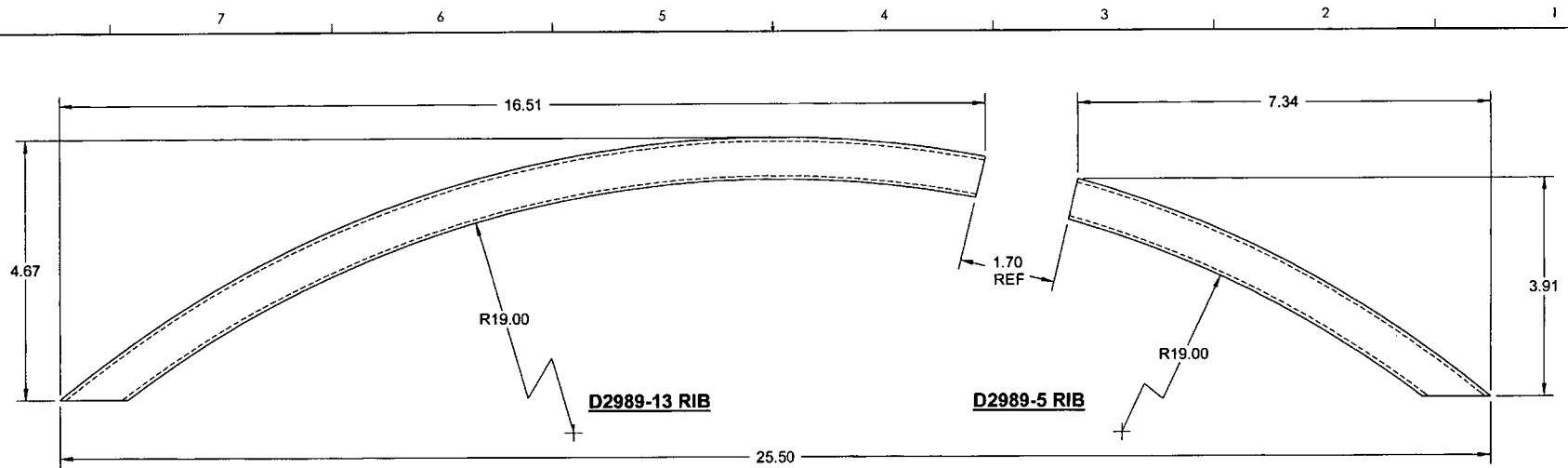
**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE 08.09.24		COPYRIGHT © 2000 BY DART AEROSPACE LTD	